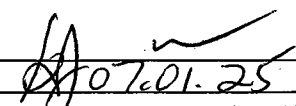
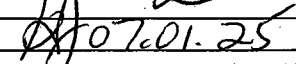


Thursday, 1/25/2007 10:22:34 AM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI UTILITY POD
Job Number :	30460		
Estimate Number :	12400		
P.O. Number :	N/A	Part Number :	D350602013
This Issue :	1/25/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2202F,DEO9217A2694G
First Issue :	N/A	Project Number :	N/A
Previous Run :	28953	Drawing Revision :	F/A/G
		Material :	N/A
Written By :		Due Date :	2/15/2007
Checked & Approved By :		Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 06-05-01 JLM Est Rev:B Added D3495-1 06-05-17 JLM		

Additional Product

Take Pod # B26657 for this job ml 07/02/12

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		
Comment: Photocopy bluefile & type labels per PPPD206-602-013 CHG001 KS 07-01-25		
2.0	D30011	Doubler
		
Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s) Doubler Batch: _____ Ship to Delastek		
3.0	D30481	Doubler
		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Doubler Batch: _____ Ship to Delastek		
4.0	PG	PURCHASING
		
Comment: PURCHASING Issue P/O: _____ Description: _____ D2202-1 Lid D2202-5 Base Supplier: Delastek Conformity Certificate and Process sheet required Ship Parts From Step 2 & 3		

Use from ~~the 74056~~ HFC

DART		TRANSPORT CANADA APPROVAL # 09-89	
P/N	D350-602-011	CHG	CHG005
DESC	Heli-Utility-Pod	STC	SH93-97
LOT	B26657	STC	SR01144NY
MODEL	AS350	STC	
MADE IN CANADA			

TEL.: 1-613-632-3336
FAX: 1-613-632-4443

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.12	ZS	PER D3048 Rev.AZ, the Qty of AD64ABS should be (44) TO MATCH THE NUMBER OF HOLES IN THE D3048-1 DOUBLER.	ml	07/02/12		CP 07.01.12 Pw PS 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 30460

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2202 and DSI 9217. Visual inspection. Check for void spot and pins.

7.0

AD64ABS

Pop Rivets



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s) 2ty 44
Pop Rivets
Batch: M15830 x25 / M19109 x 19

See sheet
for 2ty ✓

8.0

MS24693S272

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Screw
Batch: ~~148764~~

N/A ml07/02/12

9.0

D22049

Rubber Latches



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)
Rubber Latches
Batch: _____

N/A ml07/02/12

10.0

D2429041

Spring Clip Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Spring Clip Ass'y
Batch: _____

N/A ml07/02/12

11.0

D2462

Neoprene Seal



Comment: Qty.: 14.1660 f(s)/Unit Total: 14.1660 f(s)
Neoprene Seal 170.0" long
Batch: B 29456 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:22:34 AM
User: Kim Johnston

Process Sheet

Customer: _CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 30460

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D25281

Backer Plate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Backer Plate

Batch: _____

u N/A ml 07/02/12

13.0

D25283

Backer Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backer Plate

Batch: _____

u N/A ml 07/02/12

14.0

D2569

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge

Batch: ~~226709~~

u N/A already on Pod ml 07/02/12

15.0

D3007041

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: _____

u N/A ml 07/02/12

16.0

AD64ABS

Pop Rivets



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pop Rivets

Batch: _____

u N/A ml 07/02/12

17.0

AN45A

Bolt



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Bolt

Batch: M100857

(x19)

✓

18.0

AN46A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M102959

(x1)

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:22:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 30460

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN526C632R7

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch: M17864

~~As~~ ✓

20.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M6085

✓

21.0

AN960JD416

Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Batch: M16941

✓

22.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Batch: M15924

✓

23.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M100993

✓

24.0

D2258160

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Assemble as per Dwg D2694 ~~AA~~ B 21936

✓

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2694

2-Install label D2258-160 on Pod Assembly as per Dwg D2694

mld 07/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:22:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 30460

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Modify as per DEO 9217

ml 07/02/13

26.0

QC5

INSPECT WORK TO CURRENT STEP



20702.13 ①



Comment: INSPECT WORK TO CURRENT STEP

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

u

28.0

K10002

350 Pod Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

350 Pod Kit

Batch:

28030

07-02-12

29.0

D34951

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PLACARD

BATCH:

27162

u

30.0

QC4

INSPECT POWDER COAT/CHEMICAL CONVERSION



Inpat kit



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/13

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-602-013

Location:

PPP Rev:

A

07/02/13

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/13 ①

Job Completion



u 07-02-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2202	REV. F SHEET 1 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE NTS
A	93.10.27	NEW ISSUE	
B	96.12.16	ADD DOUBLERS AND HOLES	
C	97.07.04	REVISED DOUBLER/HOLE LOCATIONS	
D	98.11.09	MOVED DOUBLERS, REMOVED HOLES	
E	99.11.11	ADDED SECTIONS WITH LIP DIMS	
F	01.03.14	CHANGE LAYUP, DOUBLER, NOW DRILLED	
F1	03.05.08	ADD ALTERNATE FINISH	
F2	03.08.22	CLARIFY FOAM DIMENSION + PLACEMENT	
F3	04.10.12	CHANGE FOAM PIN PER NCR 798	

RELEASED
01.03.30 *[initials]*

EFFECTIVE	DEOs
DES 9217 REV. A 01.01.26 <i>[initials]</i>	

- 1) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE
470-36/411/510A40
FOAM: A500 CORE-CELL, OR DIVINYCELL,
OR AIREX, 0.38 THICK (3/8 FOAM)
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS (9oz SATIN)
5 OZ PLAIN WEAVE KEVLAR (5oz KEVLAR)
- 3) PEEL PLY ALL SURFACES.
- 4) FINISH: PRIMER, EPOXY PRIMER WHITE 4500-PB-40
BASE COAT, CHROMATE BASEMAKER 9175S
URETHANE CLEAR COAT, CHROMATE 7500S
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES.
- 7) ALTERNATE FINISH : INSIDE → DUPONT HIGHBUILD GREY PRIMER 1144-S
OUTSIDE → WHITE GELCOAT # GEL 944WB05

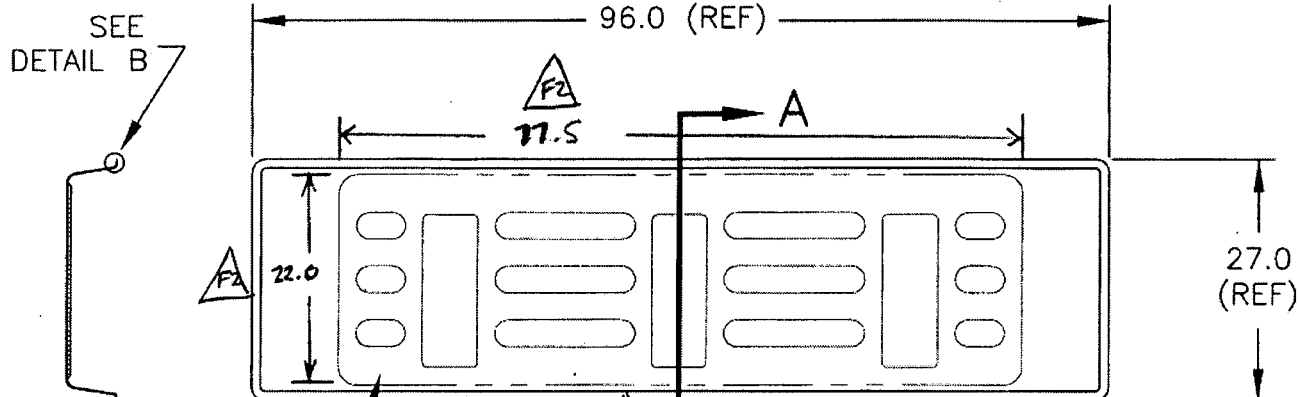
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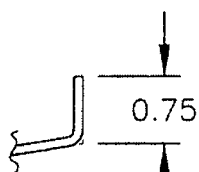


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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20



SECTION
A-A

-103 $\triangle F3$
D2202-5 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8559



DETAIL B
SCALE 1:2

D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
 $\triangle F3$ D2202-103 ~~D2202-5~~ FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN

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01.03.30 *A*

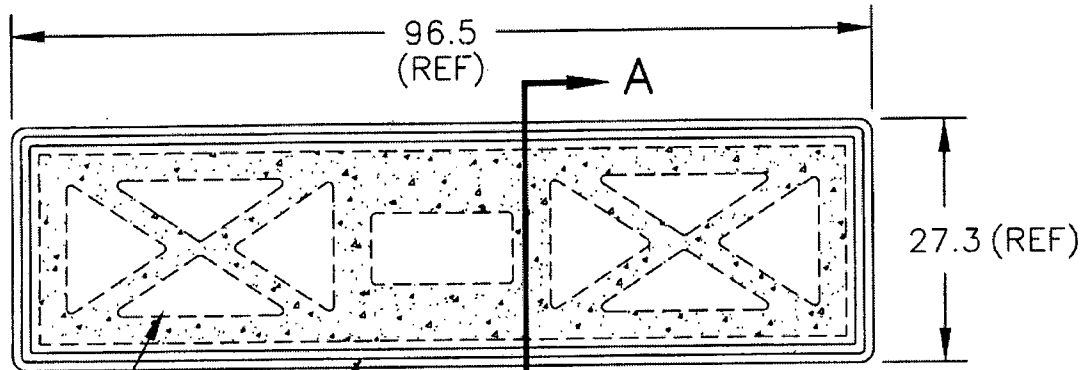
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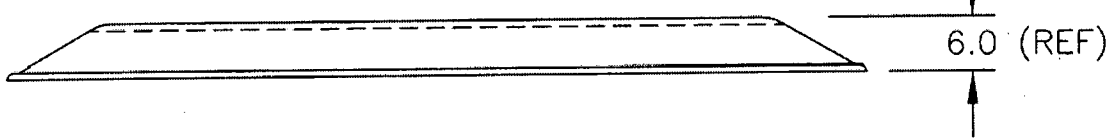
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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

SEE
DETAIL B

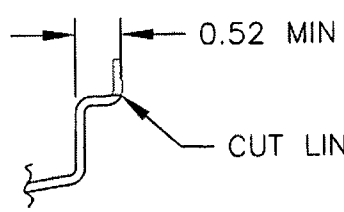


SECTION
A-A

D2202-101 F3
D2202-7 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 1:2

MAIN LAYUP

- 9oz SATIN
- 9oz SATIN
- 5oz KEVLAR
- D2202-7 FOAM CORE
- 5oz KEVLAR
- 9oz SATIN

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RELEASED
01.03.30

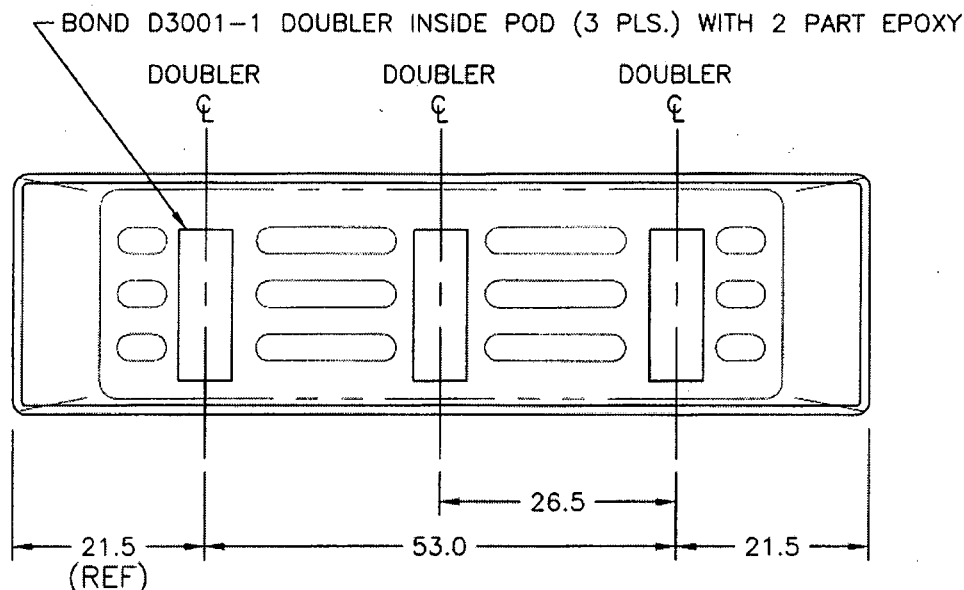
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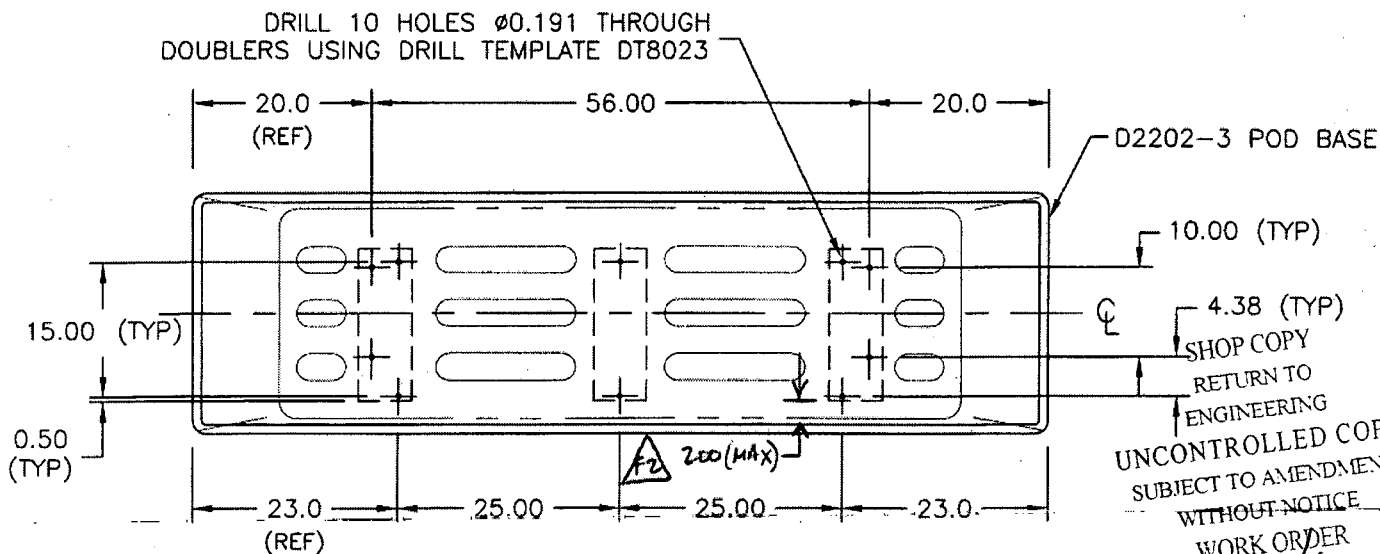


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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

RELEASED
01.03.30 *A*



D2202-3 BASE: DOUBLER INSTALLATION



D2202-3 BASE: DRILL DETAIL

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9217	REV. A SHEET 1 OF 1
DATE 01.09.26		TITLE MOsaic POD MODIFICATION	SCALE NTS
A	01.09.26	NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND D2202 REV. F

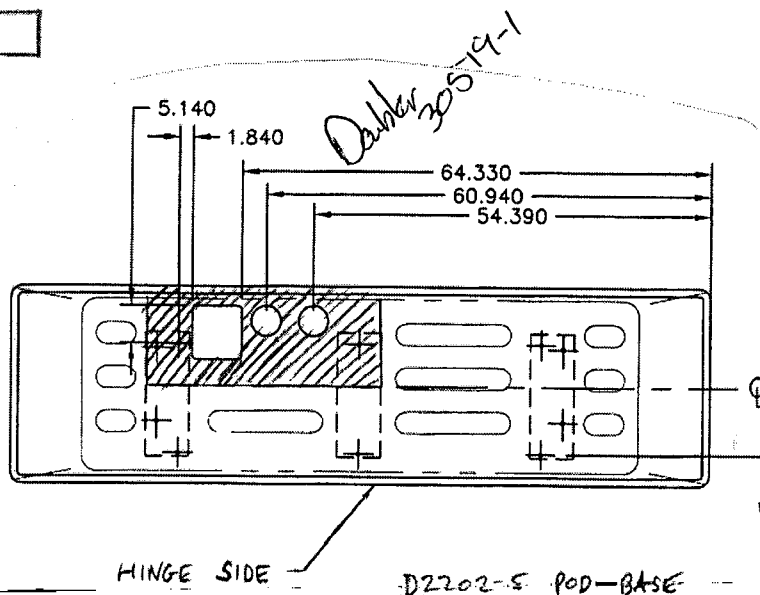
TO MAKE A D2202-5 BASE (FOR D350-602-013) FROM A D2202-3 BASE :

- 1) REMOVE FOAM IN SHADED AREA OF POD.
- 2) FILL GAPS WITH 902 SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 902 SATIN
- 4) INSTALL D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) INSTALL DOUBLER WITH AD64ABS RIVETS (46) AND MS246935212 SCREWS (3).
- 6) CUT HOLES AND SEAL WITH CYANOACRYLATE GLUE
- 7) TOUCH UP SPACKLE GREY FINISH AND CLEARCOAT.

doubler has 44 holes
GP
07.01.12

RELEASED

04.10.14 *[Signature]*



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2694	REV. G SHEET 1 OF 4
DATE 01.05.08		TITLE UTILITY POD ASSEMBLY	SCALE NTS

RELEASED
01.05.16 *#*

A	97.07.02	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043
B	97.10.08	CHANGE RIVET PATTERN, ADD D2429
C	98.11.12	ADD DOUBLER HOLES, REMOVE FINISH
D	99.01.08	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119
E	99.12.20	CHANGE DIMENSIONS
F	01.03.20	REDESIGN, CHANGE LATCHES & PROP
G	01.05.08	REVERT BACK TO D2204-9 LATCH

Qty	Part Number	Description
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2462-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD64ABS	RIVET

GENERAL NOTES:

- 1) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- 2) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE.
- 3) FOR D2569 HINGE:
 - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD.
 - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE.
 - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

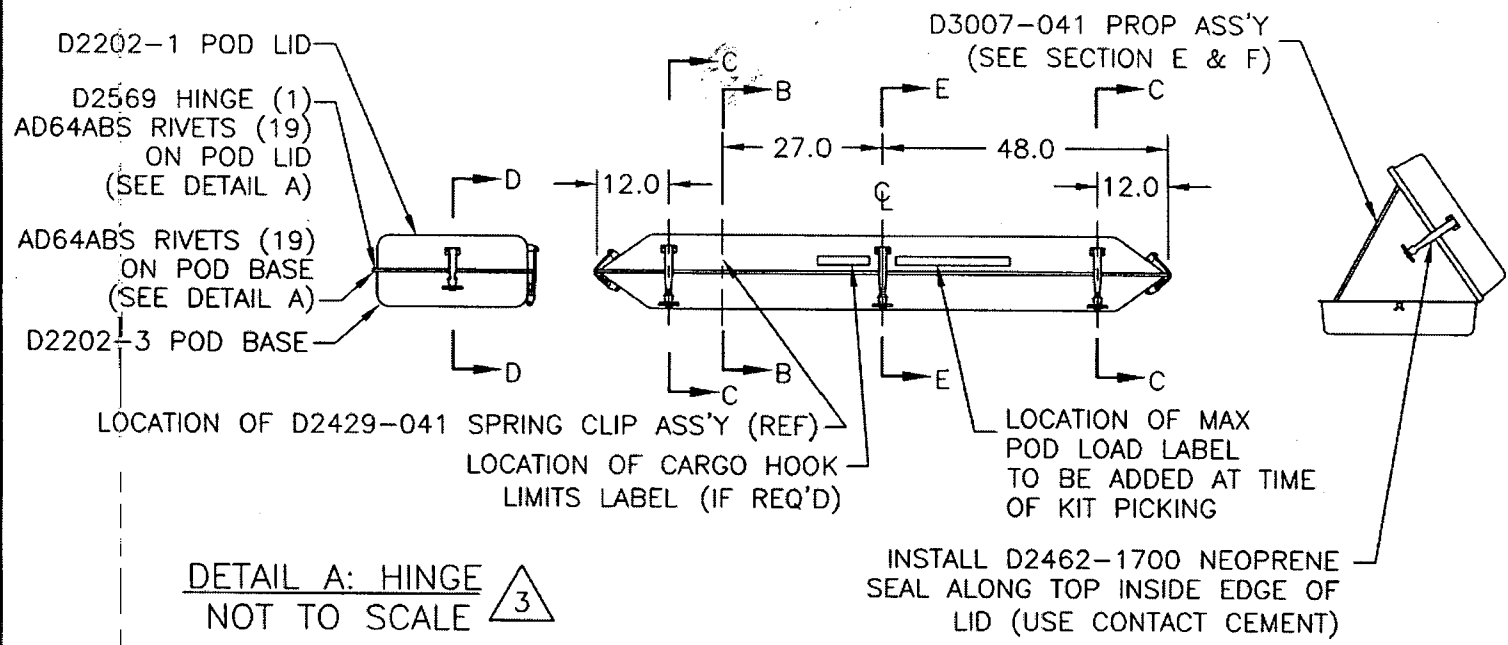
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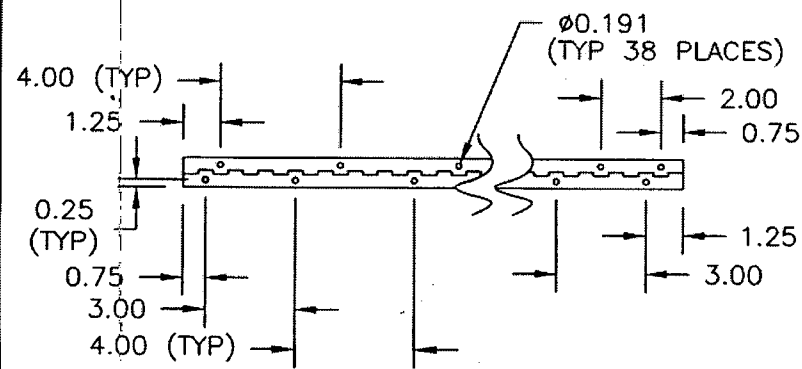
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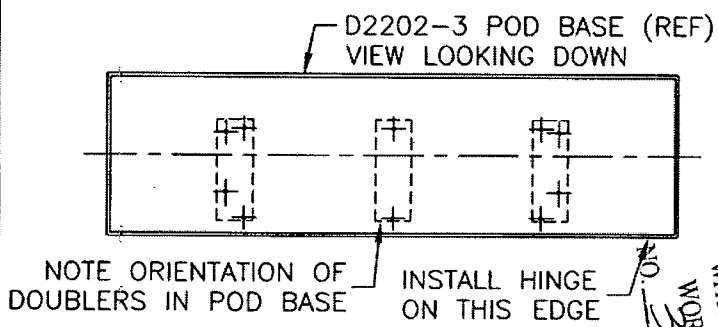
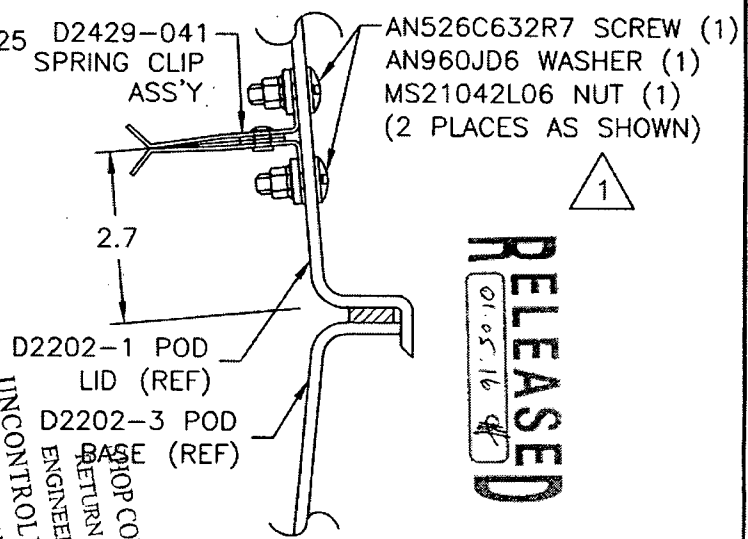
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DATE	APPROVED	DRAWING NO.	REV. 6
01.05.08		D2694	SHEET 2 OF 4
		TITLE	SCALE
		UTILITY POD ASSEMBLY	1:30



DETAIL A: HINGE
NOT TO SCALE



SECTION B-B
SCALE 2:3



RELEASED
01.05.16

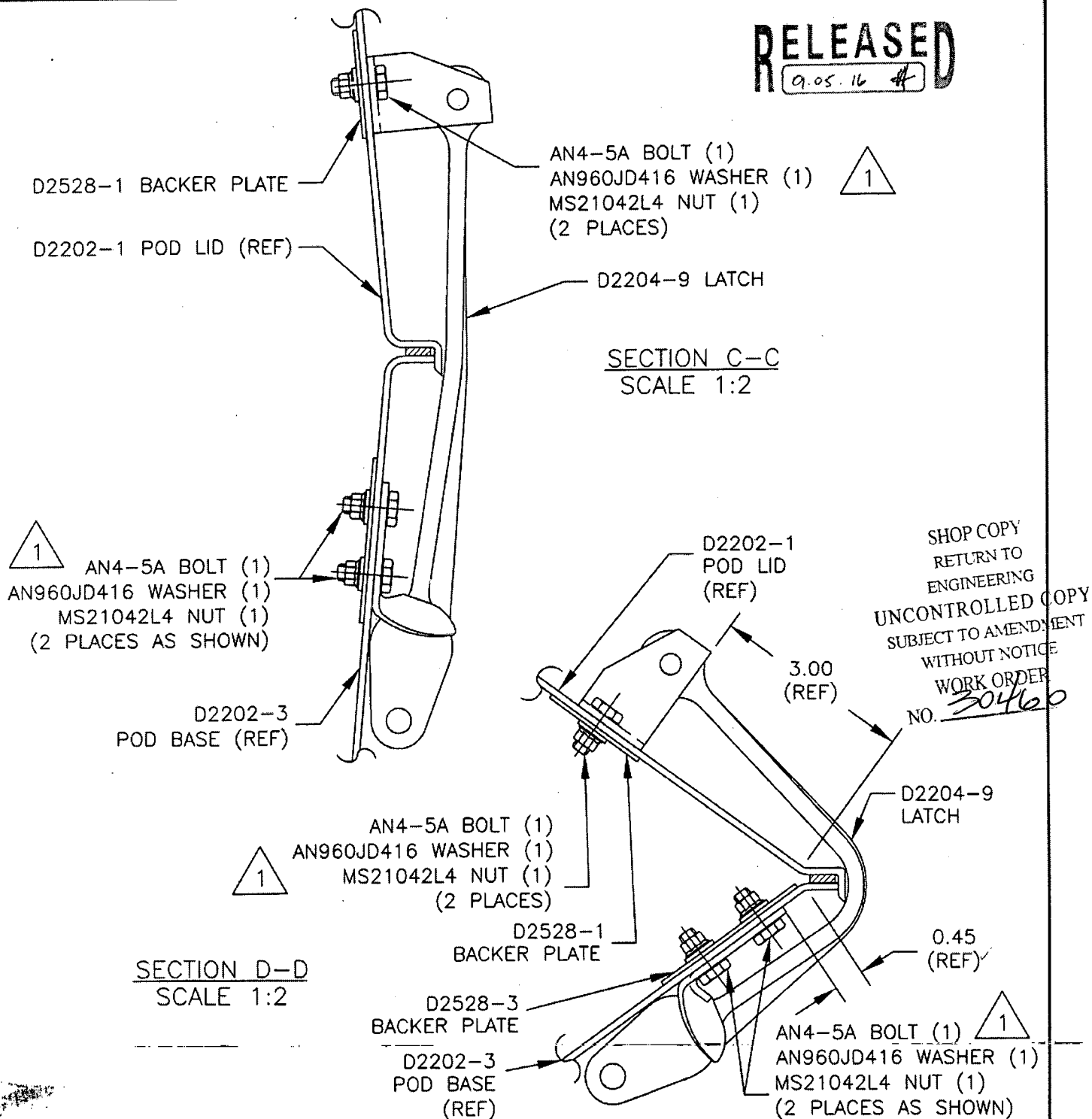
WORK ORDER
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DATE 01.05.08		TITLE UTILITY POD ASSEMBLY	SCALE 1:2

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9.05.16 *#*

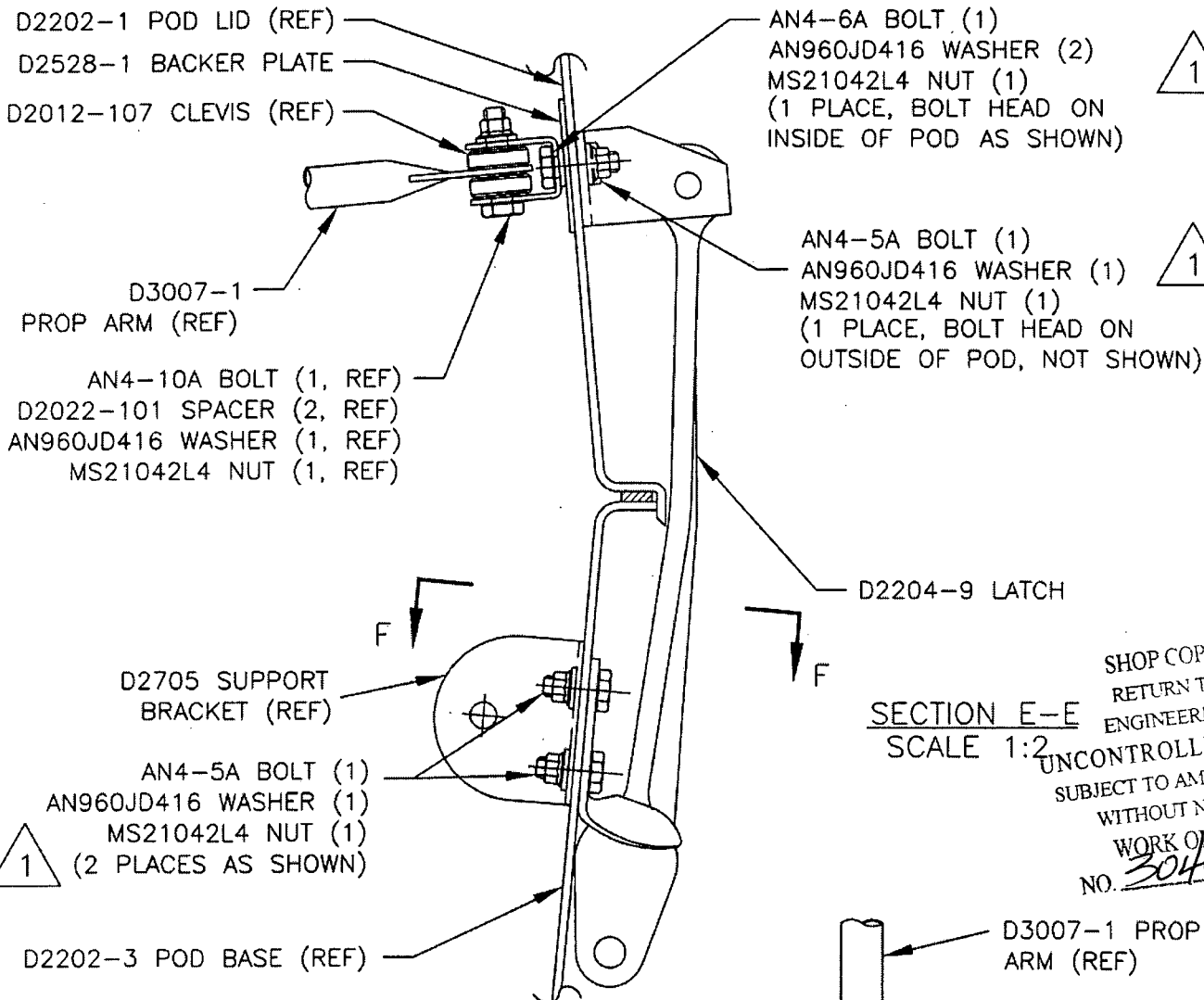


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DATE 01.05.08		TITLE UTILITY POD ASSEMBLY	SCALE 1:2



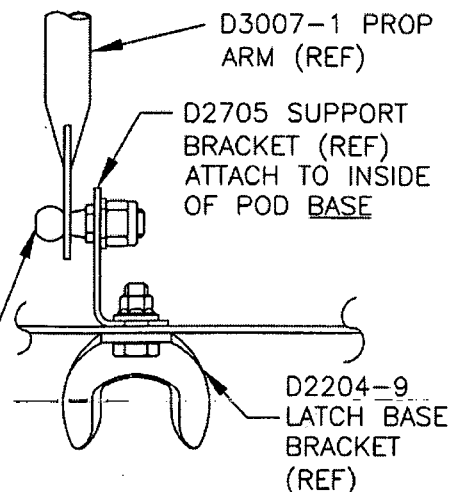
SECTION E-E
SCALE 1:2

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SECTION F-F
SCALE 1:2
SECTION ROTATED 85° CW

SL69-BS BALL STUD (1, REF)
D3015-3 LOCKNUT (1, REF)
AN960JD516 WASHER (1, REF)



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